



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1X46-175-575-1
Job Sheet 189492



Part No: RBE1X46-175-575-1

Job Qty: 4 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X46-175-575 Rev.2 IPP Rev. A 19.01.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	4 pcs	2/28/19	2/28/19	0.00	4.00	SL-2500Y - 1		DAS 56 2019-02-17
110	QC 2	4 pcs	2/28/19	2/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S155431



Part: RBE1X46-175-575-1

Job No: 189492

Serial No/Batch: S155431

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/21/19

120 NV5000 - 1 - B4B	4 pcs	2/28/19	0.00 8.00	NV5000 - 1 - B4B	P.J 19-02-26
				NV5000 - 2 - B4B	
130 QC 2	4 pcs	2/28/19	0.00 0.00	QC 2 - 1	P.J 19-02-26
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
150 QC 8	4 pcs	2/28/19	0.00 0.00	QC 8 - 12	20/19/03/19
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
180 Outsource - 4 - Anodize	4 pcs	2/28/19		ATG001-VC	10 03/19/2019 PL
190 Packaging 2-1 - Receive - B4B	4 pcs	2/28/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	

				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP MAR 26 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
200 QC 6	4 pcs	2/28/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	DAS MAR 29 2019 68 9-89
				QC 6 - 61	
210 Packaging 3-1 - Stock - B4B	4 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
220 QC 21 - SA	4 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	9-86
				QC 21 - SA - 70	

Part Op 100 - 1-Machine as per folio FC 614 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - 1-Machine as per folio FC 614 FOLIO REV: _____ DWG REV: _____ 2-Debur

150 - (QC8- Inspect parts - second check)

180 - -Issue P/O; _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Material type; 6061T6 -Certificate of Conformity is required

190 - (Receive & Inspect for Damage & Mat'l Certs)

200 - (QC6- All purchased or subcontracted products)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

APR 01 2019

GA

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R10.000	6061-T6 Round Bar 10.00"	1.7320 ft (.433 ea)	100-SL-2500Y - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M6061T6R10.000	2	5	0

Part Specifications
Specifications could not be found.

Plex 1/25/19 8:14 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



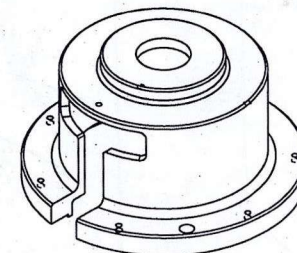
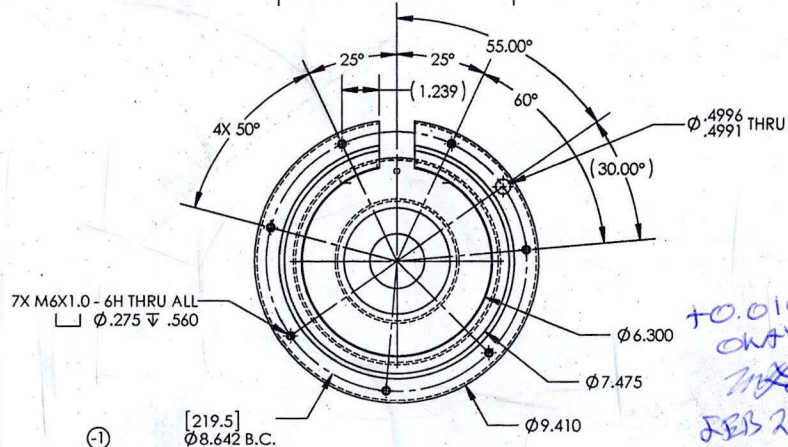
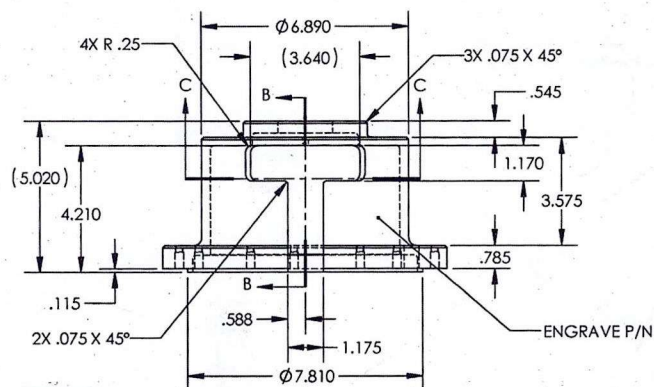
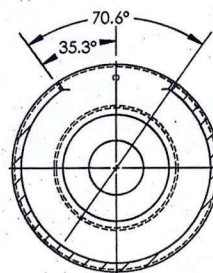
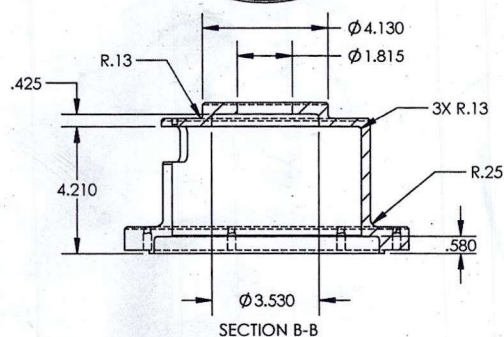
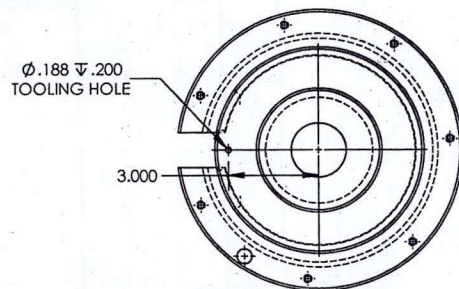
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



	
TITLE FIXTURE ASSEMBLY	
DWG NO. RBE1X46-175-575-1	REV 2
MATL 6061 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS XXX ± .01 DECIMALS XXX ± .1 ANGLES ± .1	DRAWN BY: GILBERT APPROVED: <i>D. Weid</i> REAT FINISH CLEAR ANOZIDE SPEC MIL-A-8625, TYPE II, CLASS I USED ON MODEL EC135
1. BREAK ALL SHARP EDGES .015 x .45 OR .01R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 3/15/2012 SHEET 2 OF 4

FCG14

DART AEROSPACE LTD		Work Order:
Description: FIXTURE ASSEMBLY		Part Number: RBE1X46-175-575-1
Inspection Dwg: RBE1X46-175-575-1 Rev: 2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .188 ± .000		.189 .198	✓		GP	TOOLING HOLE
3.000	± .005	3.001	✓		MGP04	
4.210	± .005	4.2085	✓		"	
.425	± .005	.4245	✓		"	
R.13	± .01	R.125	✓		R.G.	
φ 4.130	± .005	4.128	✓		MGP04	
φ 1.815	± .005	1.817	✓		"	
3x R.13	± .01	R.130	✓		R.G.	
R.25	± .01	R.25	✓		R.G.	
.580	± .005	.579	✓		MGP04	
φ 3.530	± .005	3.528	✓		MGP04	
5.020	± .005	5.019	✓		H.G.	
4.210	± .005	4.212	✓		MGP05	
4x R.25	± .01	R.25	✓		R.G.	
φ 6.890	± .005	6.888	✓		MGP04	
3x .075 x 45°	± .01 ± .5°	.080 x 45°	✓		MGP04	
.545	± .005	.5455	✓		H.G.	
1.170	± .005	1.171	✓		MGP04	
3.575	± .005	3.573	✓		H.G.	
.785	± .005	.784	✓		MGP04	
φ 7.810	± .005	7.812	✓		MGP05	
2x .075 x 45°	± .01 ± .5°	.083 x 45°	✓			
φ 6.300	± .005	6.2965	✓			
φ 7.475	± .005	7.473	✓			
φ 9.410	± .005	9.412	✓			
.115	± .005	.1145	✓		MGP05	

Measured by: 56 PMP 9-89	Checked by: 9mK	QC Inspector:
Date: 2009-02-17	Date: 19/03/19	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042923



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042923

PO Date: 3/19/19

Due Date: 3/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R191251	RBD29904-RWRRevB	Hoist Adapter "D" Model -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X10	-	3/22/19	10 pcs	0 pcs	10 pcs	\$18.00/pcs	\$180.00

MAR 25 2019 DP

Line Item Note **** RUSH - RUSH - RUSH - RUSH - RUSH ****
NEED BACK FOR MARCH 22,2019

2	189492	RBE1X46-175-575-1	Support -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4	-	3/22/19	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00
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MAR 26 2019

Line Item Note NEED BACK AT THE LATEST MARCH 27,2019

Plex 3/22/19 8:54 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042923



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188122	RBEVR-L11-0010-005-B	Press Tool -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/22/19	2 pcs	0 pcs	2 pcs	\$7.50/pcs	\$15.00
MAR 26 2019 DP											
Line Item Note: NEED BACK AT THE LATEST MARCH 27, 2019											
4	191113	RBE332A94-3400-03-15	Target Block 2 to 6 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/22/19	5 pcs	0 pcs	5 pcs	\$7.50/pcs	\$37.50
MAR 26 2019 DP											
5	191111	RBE332A94-3400-03-12	Target Block 4 & 5 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/22/19	5 pcs	0 pcs	5 pcs	\$7.50/pcs	\$37.50
MAR 26 2019 DP											

Plex 3/22/19 8:54 AM dart.Lussier.Patrick



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042923



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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Line Item Note NEED BACK AT THE LATEST MARCH 27,2019

Grand Total: \$300.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

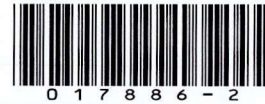
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/22/19 8:54 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



0 1 7 8 8 6 - 2

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

017886- 2

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Mar-2019		Shankar Anand		042923				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ No Qty	Qté Scrap/	À venir/ Back Order
2	RBE1X46-175-575-1 Rev.	RBE1X46-175-575-1 01 -ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	4	4	0	0	0
3	RBEVR-L11-0010-005-B Rev.	RBEVR-L11-0010-005-B 01 -ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	2	2	0	0	0
4	RBE332A94-3400-03-15 Rev.	RBE332A94-3400-03-15 01 -ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	5	5	0	0	0
5	RBE332A94-3400-03-12 Rev.	RBE332A94-3400-03-12 01 -ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.